

**Work Order ID 70462**

Thursday, June 09, 2011 7:41:28 AM



Page 1

Item ID: D3535-33

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 6/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 6.00

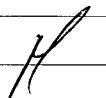


Customer:

**Reference:**

Approvals:

Process Plan:



Date: 1/06/9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D3535	Rev B								

100



FLOW WATER JET

Waterjet

## Memo

0.00

BIL-6-10

FLOW CNC Waterjet

304.640

1-Cut as per Dwg D3535  Dwg Rev: B  Prog Rev: B  2-  
Deburr if necessary

(10)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

BIL-6-10

QC

Quality Control

## Memo

0.00

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

## Memo

0.00

S u l o 6 / 1 3

(10)

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Page 2

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Start Date: 6/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 6.00



Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID**

130

**Operation  
Description****Set Up/  
Run Hours****Tool ID****Tool #****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

0.00

Brake NC

NC BRAKE

Brake NC

**Memo**

0.00

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.  2- Identify as D3535-33.

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

**Memo**

0.00

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

**Memo**

0.00

START TIME:

 OVEN TEMPERATURE:

FINISH TIME:

**Work Order ID 70462**

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Thursday, June 09, 2011 7:41:28 AM

Item ID: D3535-33

Accept



Setup

Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 6/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
Description

160



QC

QC3- Inspect Part Finish

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

10 BL 11-6-14

Memo

0.00

Quality Control

170



Identify as per dwg &amp; Stock Location:

FP-19 0.00

0.00

10X M 11/06/14

Memo

Packaging

Packaging

180



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

n 10/15/14

MF

11-06-14

# Picklist Print

Thursday, June 09, 2011 7:41:26 AM

Page 1

Work Order ID: 70462



Parent Item: D3535-33



Parent Item Name: Wearshoe

Start Date: 6/9/2011

Required Date: 6/13/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	249.9814	0.6445	4.070526	 6.5	FB11-610	

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	249.9814	
116623	0.2	
117550	10.1814	
117933	239.6	117933

16

DART AEROSPACE LTD	Work Order:	70462
Description: Wearshoe	Part Number:	D3535-33
Inspection Dwg: D3535 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>HB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	11-6-10	Date:	<u>11/06/10</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.16	New Issue	KJ	

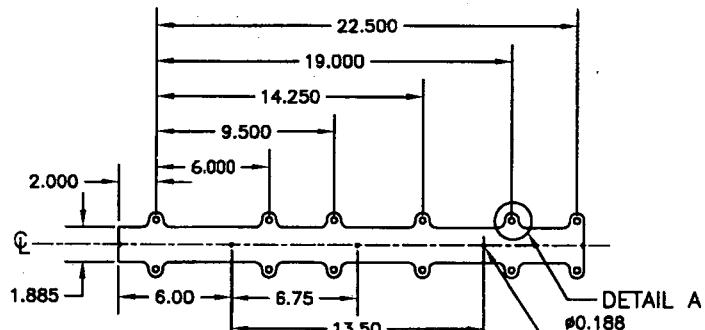
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

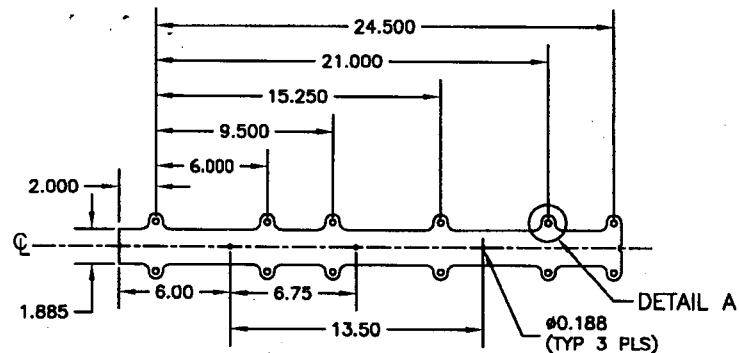
NOTE: Date & initial all entries

**DART****D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL**

RELEASED  
07.04.24

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70462

*PL 11-06-9*

**D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL**

DESIGN <b>C.B</b>	DRAWN BY <b>MH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>MH</b>	APPROVED <b>MH</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>		TITLE <b>WEARSHOE</b>
		SCALE <b>1:10</b>

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT 'C'
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

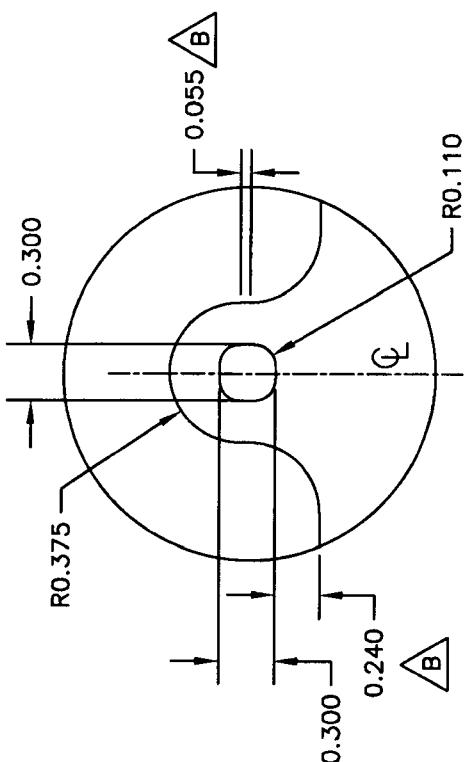
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

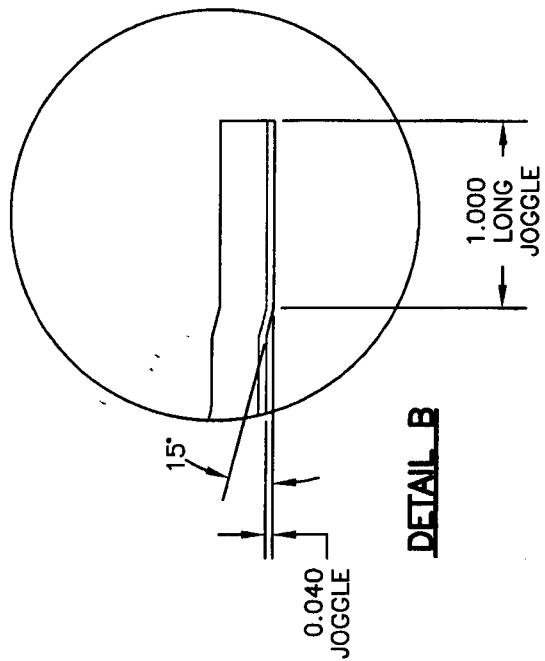
**DART**

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE	SCALE 1:1

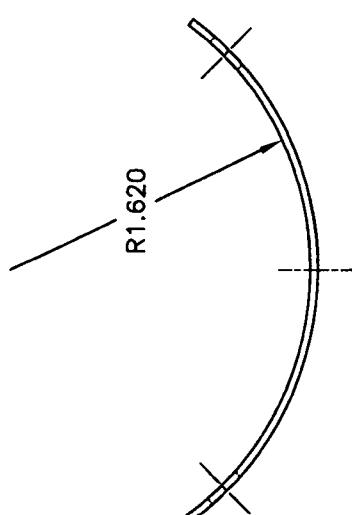
RELEASED

07.04.24 *[initials]*

DETAIL A



DETAIL B



SECTION C-C

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries